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**I** **NSTITUTIONAL**

**M** **EAT**

**P** **URCHASE**

**S** **PECIFICATIONS**

**FOR FRESH PORK PRODUCTS  
SERIES 400**

**EFFECTIVE DATE - JUNE 1997**



# **INSTITUTIONAL MEAT PURCHASE SPECIFICATIONS**

## **FOR FRESH PORK PRODUCTS**

### **SERIES 400**

The United States Department of Agriculture (USDA) through its Agricultural Marketing Service (AMS) develops and maintains the Institutional Meat Purchase Specifications (IMPS) for meat and meat products. The complete IMPS series includes the following ten documents:

General Requirements

Quality Assurance Provisions

Fresh Beef ..... Series 100

Fresh Lamb and Mutton ..... Series 200

Fresh Veal and Calf ..... Series 300

Fresh Pork ..... Series 400

Cured, Cured & Smoked, & Fully Cooked Pork Products..... Series 500

Cured, Dried, and Smoked Beef Products ..... Series 600

Variety Meats and By-Products ..... Series 700

Sausage Products ..... Series 800

These specifications are recommended for use by any meat product procuring activity. For assurance that procured items comply with these detailed requirements, the USDA, through its Meat Grading and Certification Branch, provides a voluntary Meat Certification Service. For labeling purposes, only product Certified by the Meat Grading and Certification Branch (MGC) may contain the letters "IMPS" on the product label. Purchasers desiring this service should contact:

**USDA, MRP, AMS, Livestock and Seed Division**

**Meat Grading and Certification Branch**

**Stop 0248 Room 2628 S-Bldg**

**1400 Independence Ave. SW**

**Washington, D.C. 20250-0248 Phone: (202) 720-1113 Fax: (202)-690-4119**

**Internet Address: <http://www.ams.usda.gov/lsg/lb-mg.htm>**

For any assistance regarding these documents and for additional copies, please contact:

**USDA, MRP, AMS, Livestock and Seed Division**

**Standardization Branch**

**Stop 0254 Room 2628 S-Bldg**

**1400 Independence Ave. SW**

**Washington, D.C. 20250-0254 Phone: (202) 720-4486 FAX: (202)-720-1112**

## **IMPS Ordering Checklist**

The following checklist will assist the purchaser in providing contractual language necessary to describe the IMPS product and service desired. Each element within the checklist is further defined within Section I. **ORDERING DATA TO BE SPECIFIED BY THE PURCHASER.**

- A. **Item Number** (See page 5.)
  - Special instructions
  - Purchaser Specified Options (PSO)
  - Added ingredients
  - Mechanical tenderization
- B. **Grade and Special Requirements** (See page 6.)
- C. **State of Refrigeration** (see IMPS GENERAL REQUIREMENTS, section I. MEAT HANDLING)
  - Chilled
  - Frozen
- D. **Fat Limitations** (See page 7.)
- E. **Portion Cut Weight, Thickness, and Shape** (applicable to portion cut items only (See page 8.))
- F. **Weight Range** (See weight range tables on page 9-11.)
- G. **Netting and Tying** (See page 11.)
- H. **Packaging and Packing** (See IMPS GENERAL REQUIREMENTS, section II. PACKAGING AND PACKING.)
- I. **Quality Assurance** (See IMPS QUALITY ASSURANCE PROVISIONS.)
  - Method of examination
  - Acceptable Quality Levels (AQLs)
  - Certification - (See page 11 and refer to the IMPS GENERAL REQUIREMENTS, Section III. USDA CERTIFICATION.)

## **I. ORDERING DATA TO BE SPECIFIED BY THE PURCHASER**

### A. ITEM NUMBER

The purchaser shall specify (1) IMPS item number and product name to be purchased; and (2) applicable options, modifications, and special instructions to the requirements of the IMPS. All items in this series are listed in **Table 1. INDEX OF IMPS PORK PRODUCTS AND WEIGHT RANGES** on page 9. The detailed requirements for each item are listed within the **MATERIAL REQUIREMENTS AND ITEM DESCRIPTIONS** sections of this document. In conjunction with other markings that may be required in the General Requirements and by Food Safety and Inspection Service (FSIS) Regulations, the IMPS item number, "Pork" and the product name (listed in Table 1.) shall be used for marking of shipping containers. Abbreviation of the product name is recommended. Abbreviations, when used, shall be as follows:

Boneless - Bnls	Ground - Grnd	Special - Sp
Blade - Bld	Not to exceed - NTE	Tenderloin - Tender
Bladeless - Bldls	Short Shank - Sht Shnk	Trimmed - Trmd
Cellar Trimmed - CT	Shoulder - Shld	
Center Cut - Cntr Cut	Skinned - Sknd	

The product names and abbreviations listed in this series have been reviewed and approved by USDA; FSIS; Office of Policy, Program Development, and Evaluation (OPPDE); Labeling, Product, and Technology Standards Division; Washington, D.C.

### ADDED INGREDIENTS

To enhance product performance, the purchaser may specify ingredients to be added to any IMPS fresh pork item. Ingredients may be added by immersion or injection. Unless otherwise specified, ingredients shall be limited to water, lemon juice, and sodium phosphate. The purchaser may specify any one of the following levels of added ingredients within a purchase order:

Option No.	Maximum percentage of added ingredients
1 -	7%
2 -	10%
3 -	12%
4 -	15%

The ingredients, method of addition, and labeling of product with added ingredients, shall be in accordance with FSIS Regulations.

### MECHANICAL TENDERIZATION

To enhance the tenderness of pork products, the purchaser may specify roasts or raw materials to be made into portion cuts to be mechanically tenderized. When specified, the roast or raw materials to be portioned shall be mechanically tenderized by using the multiple probe method (pinning) not more than one time.

## B. GRADE AND SPECIAL REQUIREMENTS

**Grade:** The purchaser may specify items to be derived from one or a combination of the following U.S. grades for barrow or gilt pork carcasses:

U.S. No. 1, U.S. No. 2, U.S. No. 3, U.S. No. 4, U.S. Utility.

The official standards for pork carcass grades provide for segregation according to:

- (a) class, as determined by the apparent sex condition of the animal at the time of slaughter, and
- (b) grade, which reflects quality and the expected yield of lean cuts in the carcass.

The five classes of pork carcasses are barrow, gilt, sow, stag, and boar. Grades are not provided for stag and boar carcasses. All items shall comply with the MATERIAL REQUIREMENTS for lean quality. The lean quality section describes product that is typical of meat derived from barrows or gilts. The grades are generally not applicable to item description requirements other than IMPS Item No. 400. Therefore, it is not necessary to specify grades for cuts.

**Special requirements:** The purchaser may specify any combination of the following special requirements when ordering:

Category	
U.S. Grade	1, 2, 3, 4, or Utility
Class	Barrows, gilts, boars, stags, or sows
Breed	As Specified by Purchaser
Marbling	As Specified by Purchaser
Maturity	As Specified by Purchaser
Carcass Wt. Range	As Specified by Purchaser
Diet	As Specified by Purchaser

Information regarding such requirements may be obtained from the same address as this document. The purchaser may request documentation from the vendor, stating that cuts are derived from carcasses meeting the special requirements. For certification of the special requirements, a verification program must be in place. Contact the USDA, MRP, AMS, Meat Grading and Certification Branch for development of verification programs.

## C. STATE OF REFRIGERATION

Purchaser shall specify the state of refrigeration (chilled or frozen) for delivery of product (see IMPS General Requirements for details).

## D. FAT LIMITATIONS

**Carcasses and sides:** The purchaser shall specify grade and/or maximum fat thickness as described below.

**Cuts, Roasts, and Diced Items:** The purchaser shall specify maximum surface fat thickness requirements unless fat limitations for surface and/or seam fat are indicated in the item descriptions. Maximum fat thickness requirements may be specified in terms of "average" or "at any one point". Alternative "average" and/or "at any one point" fat limitations may be specified.

Option No.	Maximum Average Thickness	Maximum At Any One Point
1	3/4 inch (19 mm) "Commodity trim"	1.0 inch (25 mm)
2	1/4 inch (6 mm)	1/2 inch (13 mm)
3	1/8 inch (3 mm)	1/4 inch (6 mm)
4	Practically Free (75% lean/seam surface exposed)	1/8 inch (3 mm)
5	Peeled/Denuded* (remaining fat shall not exceed 1.0 inch (25 mm) in the longest dimension and/or 1/8 inch (3 mm) in thickness)	1/8 inch (3 mm)
6	Peeled/Denuded, Surface Membrane Removed** (90% lean exposed)	1/8 inch (3 mm)

\*and\*\* - See Fat Trim beginning on page 13 for definition.

Note: When average fat thickness are specified by the purchaser or in item descriptions, the appropriate "Maximum at Any One Point" limitation shall apply.

**Portion-Cuts:** The purchaser shall specify the maximum (at any one point) thickness of surface fat on the edges of the portion cut unless fat limitations for surface and/or seam fat are indicated in the detailed item descriptions. Alternative fat limitations may be specified. If not specified, surface fat thickness shall not exceed 1/4 inch (6 mm) at any one point.

Option No.	Maximum fat thickness at any one point for portion cuts
1	1/4 Inch (6 mm)
2	1/8 inch (3 mm)
3	Practically free (75% lean/seam surface exposed and remaining fat shall not exceed 1/4 inch (6 mm))
4	Peeled/Denuded* (remaining fat shall not exceed 1.0 inch (25 mm) in the longest dimension and/or 1/8 inch (3 mm) in thickness)
5	Peeled/Denuded, Surface Membrane Removed** (90% lean exposed and remaining fat shall not exceed 1/8 inch (3 mm))

\*and\*\* - See Fat Trim beginning on page 15 for definition

**Items that are Ground, Flaked and Formed, Sliced and Formed, Coarse Chopped, Trimmings, and Diced:** When specified, fat limitations for these items shall be expressed in terms of a fat content percentage. Fat content describes the percentage of fat present in the product. Unless otherwise specified, the fat content of ground and flaked and formed shall not exceed 22 percent. However, the purchaser may specify any fat content provided it does not exceed 30 percent and may specify discount ranges.

The purchaser shall specify the fat content analysis to be determined on a 1) composite analysis, or 2) average analysis method (as defined within the IMPS QUALITY ASSURANCE PROVISIONS.) If the purchaser does not specify either method, the procedures for average fat content analysis method shall be used.

The fat content shall be specified by the purchaser and verified by one or any combination of the following purchaser specified options (PSO). If not specified, the fat content shall be verified with PSO #2 requirements.

- PSO:
- 1- Fat content shall be declared on the product label along with a nutrition fact panel in accordance with FSIS regulations
  - 2- Contractor shall submit documentation of fat analysis to purchaser
  - 3- Fat content certified by AMS (see Quality Assurance Provisions)
  - 4- Samples selected by AMS and sent to purchaser designated laboratory

## E. PORTION-CUT WEIGHT, THICKNESS AND SHAPE

**Weight and thickness:** The purchaser shall specify the portion weight and/or thickness desired. For assistance in specifying weight, see weight range tables. Unless the purchaser specifies other portion weight and/or thickness tolerances, the following tables shall be used. When both weight and thickness are specified, it is recommended that those requirements be limited to items that are mechanically pressed and/or sliced.

### PORTION THICKNESS TOLERANCES <sup>1/</sup>

Specified Thickness	Thickness Tolerance	Thickness Uniformity
1 inch (25 mm) or less	+/- 3/16 inch (5 mm)	3/16 inch (5 mm)
More than 1 inch (25 mm)	+/- 1/4 inch (6 mm)	1/4 inch (6 mm)

### PORTION WEIGHT TOLERANCES

Specified Weight	Weight Tolerance	Thickness Uniformity <sup>1/</sup>
Less than 6.0 ounces (170 g)	+/- 1/4 oz. (7 g)	3/16 inch (5 mm)
6.0 (170 g) to 12.0 ounces (340 g)	+/- 1/2 oz. (14 g)	1/4 inch (6 mm)
12.01 (341 g) to 24.0 ounces (680 g)	+/- 3/4 oz. (21 g)	3/8 inch (9 mm)
24.01 ounces (681 g) or more	+/- 1 oz. (28 g)	1/2 inch (13 mm)

<sup>1/</sup> - Thickness measurements are not applicable within 1/4 inch (6 mm) of the edge. Also, value listed under thickness uniformity is the maximum allowable difference between the thinnest and thickest measurement of an individual chop or steak.

**Shape:** Unless otherwise specified, the shape of whole muscle portions cuts shall resemble the approximate shape relative to the cut of origin. Cubed and braising steaks that are mechanically pressed and sliced shall be uniform in shape. Unless otherwise specified, patties shall be round.

## F. WEIGHT RANGE



Purchaser shall specify IMPS item number, product name, and weight range to be purchased. The following weight ranges are intended as guidelines. Carcass weights are not necessarily related to the weight of cuts within their respective weight range. Other weights or ranges may be specified.

**Table 1. INDEX OF IMPS PORK PRODUCTS AND WEIGHT RANGES**

Item No.	Product Name	Weight Ranges (Pounds)				Page
		Range A	Range B	Range C	Range D	
400	Carcass .....	120-150	150-180	180-210	210-up	16
400A	Whole Roasting Pig.....	12-24	24-40	40-60	100-up	17
401	Leg (Fresh Ham) .....	14-17	17-20	20-26	26-up	17
401A	Leg (Fresh Ham), Short Shank .....	14-17	17-20	20-26	26-up	17
401B	Leg (Fresh Ham), Sirloin On .....	16-18	18-22	22-28	28-up	17
401C	Leg (Fresh Ham), Semi-boneless .....	14-16	16-18	18-20	20-up	18
402	Leg (Fresh Ham), Skinned .....	14-17	17-20	20-26	26-up	18
402A	Leg (Fresh Ham), Skinned Short Shank.....	14-17	17-20	20-26	26-up	18
402B	Leg (Fresh Ham), Boneless .....	6-8	8-10	10-12	12-up	18
402C	Leg (Fresh Ham), Boneless, Short Shank, Trimmed .....	6-8	8-10	10-12	12-up	18
402D	Leg (Fresh Ham), Outside.....	2-4	4-5	5-6	6-up	19
402E	Leg (Fresh Ham), Outside, Trimmed ...	2-3	3-5	5-up		19
402F	Leg (Fresh Ham), Inside .....	3-dn	3-4	4-5	5-up	19
402G	Leg (Fresh Ham), TBS, 3-Way, Boneless.....	12-14	14-16	16-18	18-up	19
402H	Pork Leg (Fresh Ham), Tip,.....	0.5-1.5	1.5-3	3-up		19
403	Shoulder .....	8-12	12-16	16-20	20-up	20
403A	Shoulder, Long Cut .....	10-14	14-18	18-22	22-up	20
403B	Outside Shoulder.....	8-12	12-16	16-20	20-up	20
403C	Inside Shoulder, Boneless.....	2-4	4-8	8-up		21
404	Shoulder, Skinned .....	8-12	12-16	16-20	20-up	21
405	Shoulder, Picnic .....	4-6	6-8	8-12	12-up	21
405A	Shoulder, Picnic, Boneless.....	2-4	4-6	6-8	8-up	22
405B	Shoulder, Picnic, Cushion .....			(Amount as Specified)		22
406	Shoulder, Boston Butt .....	2-4	4-8	8-up		22
406A	Shoulder, Boston Butt, Boneless.....	2-4	4-8	8-up		22
406B	Shoulder, Boston Butt Boneless, Special.....	2-4	4-6	6-8	8-up	22
407	Shoulder Butt, Cellar Trimmed, Boneless.....	1.5-3	3-4	4-7	7-up	22
408	Belly.....	10-12	12-14	14-18	18-up	22
409	Belly, Skinless .....	7-9	9-11	11-13	13-up	23
409A	Belly, Single Ribbed, Skinless .....	10-12	12-14	14-18	18-up	23
409B	Belly, Center Cut, Skinless .....	7-9	9-11	11-13	13-up	23
410	Loin.....	10-14	14-19	19-22	22-up	24

Item No.	Product Name	Weight Ranges (Pounds)				Page
		Range A	Range B	Range C	Range D	
410A	Sirloin .....	2-4	4-8	8-10	10-up	24
411	Loin, Bladeless .....	10-14	14-18	18-22	22-up	24
412	Loin, Center Cut, 8 Ribs .....	4-6	6-8	8-10	10-up	25
412A	Loin, Center Cut, 8 Ribs, Chine Bone Off.....	4-5	5-7	7-9	9-up	25
412B	Loin, Center Cut, 8 Ribs, Boneless.....	2-4	4-5	4-6	6-up	25
412C	Loin, Center Cut, 11 Ribs .....	5-7	7-9	9-11	11-up	25

412D	Loin, Center Cut, 11 Ribs, Chine Bone Off.....	4-6	6-8	8-10	10-up	26
412E	Loin, Center Cut, 11 Ribs, Boneless .....	3-5	5-6	6-7	7-up	26
412F	Loin, Center Cut, Rib End, Boneless.....	1-1.5	1.5-2	2 and up		26
412G	Pork Loin, Center Cut, Rib End .....	1.5-2	2-4	4 and up		26
413	Loin, Boneless.....	6-8	8-10	10-12	12-up	26
413A	Loin, Roast, Boneless .....	6-8	8-10	10-12	12-up	27
413B	Loin, Boneless, Special .....	6-8	8-10	10-12	12-up	27
414	Loin, Canadian Back .....	3-4	4-5	5-6	6-up	28
414A	Sirloin, Boneless.....	1-3	3-5	5-9		28
415	Tenderloin .....	0.5-1	1-1.5	1.5-up		28
415A	Tenderloin, Side Muscle Off.....	0.5-1	1-1.5	1.5-up		28
416	Spareribs .....	2.5-dn	2.5-4	4-6	6-up	29
416A	Spareribs, St. Louis Style .....	1.5-2	2-3	3-up		29
416B	Spareribs, Brisket Bones.....	0.25-0.33	0.33-0.5	0.5-0.75	0.75-up	29
416C	Spareribs, Breast Off.....	2.5-dn	2.5-3.5	3.5-5.5	5.5-up	29
416D	Breast Bones.....	under 1	over 1			29
417	Shoulder Hocks.....	0.25-0.75	0.75-1.5	1.5-up		29
417A	Leg (Fresh Ham) Hocks.....		(Not Applicable)			29
418	Trimming .....		(Not Applicable)			29
419	Jowl .....	0.5-1.5	1.5-up			30
420	Pig's Feet, Front .....		(Not Applicable)			30
420A	Pig's Feet, Hind .....		(Not Applicable)			30
421	Neck Bones.....		(As Specified)			30
422	Loin, Back Ribs .....	1.5-dn	1.5-1.75	1.75-2.25	2.25-up	30
423	Loin, Country-Style Ribs.....	2-3	3-up			30
424	Loin, Riblet .....		(Not Applicable)			31
435	Diced Pork.....		(As Specified)			31
435A	Pork for Stewing .....		(As specified)			31
435B	Pork for Kabobs .....		(As specified)			31
496	Ground Pork .....		(As Specified)			31
496A	Ground Pork and Vegetable Protein .....					
	Product.....		(As Specified)			32
496B	Pork Patty Mix .....		(As Specified)			33
496C	Pork Patty Mix, NTE 10% Fat.....		(As Specified)			33

## PORTION-CUT ITEMS

Item No.	Product Name	Suggested portion weight range (Ounces)	page
1400	Steak Cubed.....	3 - 8	34
1401	Steaks Cubed, Special.....	3 - 8	34
1402	Cutlets .....	3 - 8	34
1402G	Leg Cutlets .....	3 - 8	34
1406	Boston Butt Steaks.....	4 - 8	34
1407	Shoulder Butt Steaks, Boneless.....	3 - 8	35
1410	Loin Chops .....	3 - 8	35

1410A	Loin, Rib Chops.....	3 - 8 .....	35
1410B	Loin, End Chops.....	4 - 8 .....	35
1411	Loin Chops, Bladeless.....	3 - 8 .....	35
1412	Loin Chops, Center Cut.....	3 - 8 .....	35
1412A	Loin Chops, Center Cut, Chine Bone Off .....	3 - 8 .....	35
1412B	Loin Chops, Center Cut, Boneless.....	3 - 8 .....	35
1412E	Loin Chops, Center Cut, One Muscle, Boneless.....	6 - 8 .....	35
1413	Loin Chops, Boneless .....	3 - 8 .....	36
1413B	Loin, End Chops, Boneless .....	3 - 6 .....	36
1438	Steaks, Flaked and Formed, Frozen.....	Amount as Specified .....	36
1438A	Sandwich Steaks, Flaked, Chopped, Formed and Wafer Sliced, Frozen .....	Amount as Specified .....	36
1438B	Steaks, Sliced and Formed, Frozen.....	Amount as Specified .....	36
1495	Coarse Chopped Pork.....	Amount as Specified .....	36
1496	Ground Pork Patties.....	Amount as Specified .....	37
1496A	Ground Pork and Vegetable Protein Product Patties .....	Amount as Specified .....	37
1496B	Pork Patties.....	Amount as Specified .....	37
1496C	Pork Patties, NTE 10% Fat .....	Amount as Specified .....	37

## **G. NETTING AND TYING**

Many of the item descriptions require roasts to be netted or tied to facilitate institutional style cookery methods. The purchaser may specify the netting and tying requirements for such items as needed.

## **H. PACKAGING AND PACKING**

Purchaser shall specify packaging and packing for delivery of product (see IMPS General Requirements for details).

## **I. QUALITY ASSURANCE**

The purchaser may consult the IMPS Quality Assurance Provisions for options regarding production examination and lot acceptance criteria in terms of acceptable quality levels (AQL's).

**USDA CERTIFICATION** - When requested, the purchaser shall specify within a contract or purchase order that product shall be certified by USDA, AMS, Meat Grading and Certification Branch. The purchaser shall consult the IMPS Quality Assurance Provisions for options regarding product examination and lot acceptance criteria in terms of acceptable quality levels (AQL s). For more information regarding this service, contact:

**USDA, MRP, AMS, Livestock and Seed Division**  
**Meat Grading and Certification Branch**  
**Stop 0248 Room 2628 S-Bldg**  
**1400 Independence Ave. SW**  
**Washington, D.C. 20250-0248 Phone: (202) 720-1113 Fax: (202)-690-4119**

**Internet Address: <http://www.ams.usda.gov/lsg/lsg.htm>**

## **II. MATERIAL REQUIREMENTS**

All products offered shall comply with the following material requirements and the individual item descriptions. For certification, product shall be evaluated in accordance with the IMPS QUALITY ASSURANCE PROVISIONS.

### **A. QUALITY**

#### **1. Condition**

All products offered as meeting the specification requirements must be in excellent condition. For certification, product shall be in the fresh-chilled state (not previously frozen) when examined for excellent condition; i.e., exposed lean and fat surfaces shall be of a color and bloom normally associated with the class, grade, and cut of meat, and typical of meat which has been properly stored and handled. Cut surfaces and naturally exposed lean surfaces shall show no more than slight darkening or discoloration due to dehydration, aging, and/or microbial activity. The fat shall show no more than very slight discoloration due to oxidation or microbial activity. No odors foreign to fresh meat shall be present. Changes in color and odors characteristically associated with vacuum-packaged meat in excellent condition shall be acceptable. Also, product shall show no evidence of freezing, defrosting, or mishandling. Pork must be maintained in excellent condition through processing, storage, and transit.

Portion-cut and ground items to be delivered frozen may be produced from frozen meat cuts which have been previously certified in the fresh-chilled state, provided such cuts show no evidence of deterioration. Unless otherwise specified, portion-cut items shall maintain their approximate original shape. Products thus produced shall be packaged, packed, and returned promptly to the freezer.

#### **2. Lean Quality**

All pork shall be practically free from bruises, blood clots, bloody tissue, blood discoloration, exposed spinal cord portions, or any other conditions that would negatively affect the use of the product.

The lean must: (1) be at least slightly firm; (2) possess a bright, reasonably uniform color (slight two-toned color is permissible), ranging from light pink to light red; (3) have a fine, smooth texture; and (4) exhibit no evidence of the pale, soft, and exudative (PSE) condition. The skin must be thin, smooth, and pliable. Dark, coarse textured lean, oily and soft fat shall not be acceptable.

#### **3. Workmanship**

##### **a. Cutting, Trimming, and Boning**

The cutting, trimming, and boning of cuts shall be accomplished with sufficient care to allow each cut to retain its identity and to avoid objectionable scores in the lean. Ragged

edges shall be removed close to the lean surfaces. Except for cuts that are separated through natural seams, all cut surfaces shall form approximate right angles with the skin surface. With the exception of specifically defined cut separations, no more than a slight amount of lean, fat, or bone shall be removed or included from an adjacent cut.

Except for chops which are cubed or unless otherwise specified in the individual item description, chops shall be cut in full slices in a straight line reasonably perpendicular to the outer surface and at an approximate right angle to the length of the cut being sliced or portioned. The entire cut shall be sliced from end to end, and all suitable portions shall be included. Portion-cut items shall be practically free of (1) fractures, (2) tag ends, and (3) knife scores. Individual chops shall remain intact when suspended 1/2 inch (13 mm) from the outer edge.

#### b. Fat Trim

Trimming to remove fat on the exterior surface of a cut shall be accomplished by smoothly removing the fat following the contour of the underlying muscle surface. Beveling of the edges only is not acceptable. Two terms used for describing fat trim limitations are: (1) maximum fat thickness at any one point and (2) average fat thickness. Fat thickness requirements may apply to surface fat (external and/or exterior fat in relationship to the item) and seam fat (fat between adjacent muscles within an item) as specified by the purchaser or within the detailed item description.

Peeled/Denuded - The term "peeled" implies surface fat and muscle separation through natural seams so that the resulting cut's seamed surface ("silver" or "blue" tissue) is exposed with remaining "flake" fat not to exceed 1.0 inch (25 mm) in the longest dimension and/or 1/8 inch (3 mm) in depth at any point. The term "denuded" implies all surface fat is removed so that the resulting cut's seamed surface ("silver" or "blue tissue") is exposed with remaining "flake" fat not to exceed 1.0 inch (25 mm) in any dimension and/or 1/8 inch (3 mm) in depth at any point.

Peeled/Denuded, Surface Membrane Removed - When the surface membrane ("silver" or "blue" tissue) is required to be removed (skinned), the resulting cut surface shall expose at least 90% lean with remaining "flake" fat not to exceed 1/8 inch (3 mm) in depth.

Cuts and roast items - The maximum fat thickness at any one point is evaluated by visually determining the area of a cut which has the most fat thickness and measure the thickness (depth) at this point. The average fat thickness is evaluated by visually determining the areas of surface fat and taking multiple measurements in these areas only. The average shall be determined by evaluating the amount of surface area that each thickness represents (e.g., if one third of the fat surface was 0.2 inch in depth, one third was 0.3 inch in depth and one third was 0.4 inch in depth, then the average would be 0.3 inch).

When a natural depression occurs in a muscle, only the fat above the portion of the depression which is more than 3/4 inch (19 mm) in width is considered (this method is known as "bridging"). When a seam of fat occurs between adjacent muscles only the fat above the level of the involved muscles is measured (this method is known as "planing") (See Figure 1).

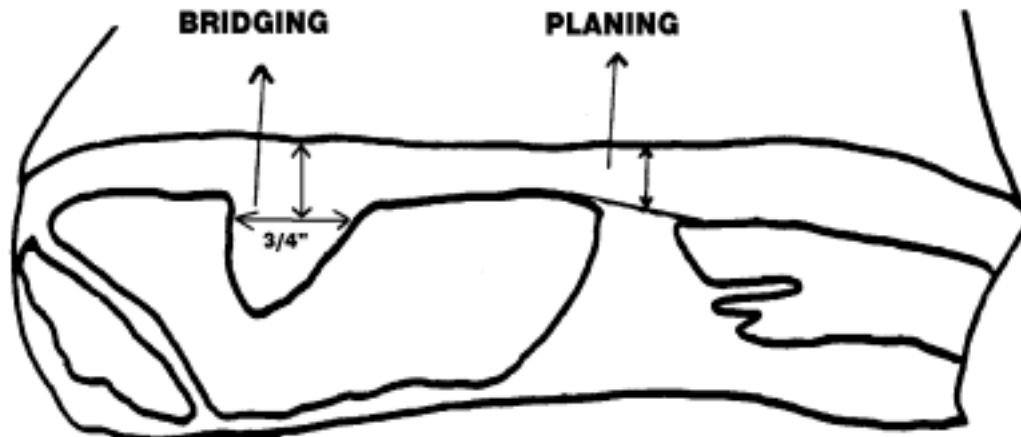


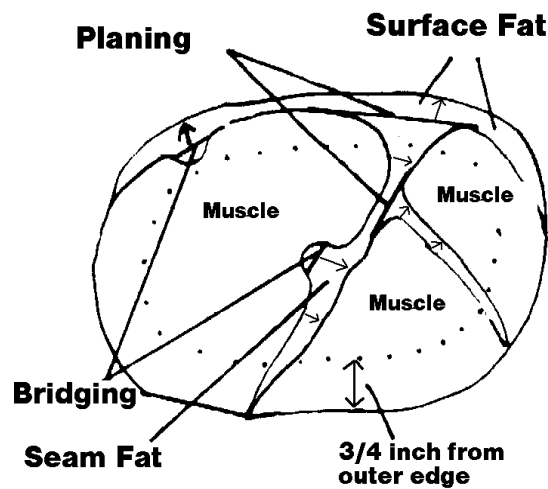
Figure 1

However, when fat limitations for Peeled/Denuded or Peeled/Denuded, Surface Membrane Removed are specified, the bridging method shall be used for evaluating fat above a natural depression in a muscle and fat occurring between adjacent muscles.

Diced and portion-cut items - For the purpose of measuring surface fat, the maximum fat thickness at any one point is evaluated by determining the areas on the edges of either side of the dice or portion-cut which has the thickest amount of fat, and measuring the thickness (depth) of fat in these areas. The average fat thickness is evaluated by visually determining the various areas of surface fat and taking multiple measurements in these areas. The average shall be determined by evaluating the amount of surface area that each thickness represents.

The actual measurements of fat are made on the edges of the cut and by probing or scoring the fat surface as necessary in a manner that reveals the actual fat thickness. For portion-cut items, the bridging and/or the planing methods shall be applied to take into account any natural depression occurring in a muscle and/or when a seam of fat occurs between adjacent muscles (See Figure 2).

However, when fat limitations for Peeled/Denuded or Peeled/Denuded, Surface Membrane Removed are specified, the bridging method shall be used for evaluating fat above a natural depression in a muscle and fat occurring between adjacent muscles.



For the purpose of measuring seam fat, when specified, the maximum fat thickness at any one point is evaluated by visually determining the areas of fat between layers of lean (muscles) on any side of the cut which have the thickest (widest) deposits of fat and measuring the width in these areas. The average fat thickness is evaluated by visually determining the various areas of seam fat and taking multiple measurements in these areas. The average shall be determined by evaluating the areas that each thickness (width) represents.

For steak items, the bridging and/or planing methods shall be applied to take into account

Figure 2 the irregular

widths of the seam fat within a

muscle depression or between adjacent muscles in

order to reveal the actual fat thickness (width) of fat within a seam. Seam fat shall be evaluated no closer than 3/4 inch (19 mm) from the contour (projected perimeter when symmetrically formed or unformed) of the outer edge of the steak (See Figure 2).

#### 4. Muscling

Fresh hams, shoulders, shoulder picnics, Boston butts, and loins must have at least a moderate degree of meatiness, based on a composite evaluation of thickness of muscling and quantity of intermuscular and external fat.

Bellies must indicate at least a slightly high ratio of lean to fat and have uniform distribution of fat and lean layers. They may vary in thickness from slightly thick to moderately thick and must be moderately uniform in thickness and moderately long in relation to their width.

### **5. Skeletal Condition**

When present, bones must not be ossified to a degree that cartilage is not evident in the pelvic, spinal, and scapular sections. The split chine bones, spinous processes, and cross-cut sections of bones must be porous. The color of the bones must range from red to deep pink. The exterior surfaces of the rib bones must show at least some redness.

Pork cuts shall be free of dislocated or enlarged joints or other malformations of the skeletal structure. However, cuts with bones broken during processing are acceptable if the bones are not splintered to the extent that the lean around the fracture is affected.

### **6. Netting or Tying**

When tying is required, stretchable netting (or any other equivalent material) shall be used to make roasts firm and compact. Unless otherwise specified, roasts shall be netted so that all portions are held intact, without any portions protruding through the ends of the netting. Alternatively, roasts may be string tied by loops of twine uniformly spaced at no more than approximately 2.0 inches (5.0 cm) intervals girthwise (perpendicular to item length). When girthwise tying does not make roasts firm and compact, lengthwise tying shall also be used. For net weight verification, netting material shall be included along with packaging materials when determining tare weight.

## **III. ITEM DESCRIPTIONS**

Note: A reference for identification of muscles is "Porcine Myology" by R. G. Kauffman and L. E. St. Clair, Bulletin 715, University of Illinois College of Agriculture, Agricultural Experiment Station. Copies may be obtained at a nominal cost from: Office of Agricultural Publications, University of Illinois, 47 Mumford Hall, 1301 Gregory Drive, Urbana, Illinois 61801.

**Item No. 400 - Pork Carcass** - The carcass shall be dressed "packer style"; i.e., without the head and kidneys and practically free of internal fat. There shall not be any objectionable scores on the outside of the carcass and, unless otherwise specified, the carcass shall be skin-on. Mutilated feet must be removed at the hock or upper knee joint (as applicable). Carcasses with a "stuck" shoulder are not acceptable. The membranous portion of the diaphragm must be removed close to the lean, although the lean portion (and the membrane surrounding the lean portion) may remain, if firmly attached to the carcass. The jowl may remain intact with each carcass side, except that minor trimming is acceptable for removal of bloody portions and ragged edges. However, excessively trimmed or mutilated jowls shall be removed by a reasonably straight cut perpendicular to the length of the carcass and is not more than 1.0 inch (25 mm) anterior to the ear dip. The carcasses shall be split into reasonably uniform sides by cutting lengthwise through the backbone so that the major muscles of the loin and shoulder are not scored and such that the spinal cord groove is evident on at least 75 percent of both sides of the backbone.



**Item No. 400A - Whole Roasting Pig** - This item is as described in Item No. 400 except that the carcass shall not be split, the head shall remain, internal fat and membranous portion of the diaphragm may remain.

**Item No. 401 - Pork Leg (Fresh Ham)** - The leg is separated from the side by a straight cut approximately perpendicular to a line parallel to the shank bones. The cut passes through a point which is not less than 1.5 inches (3.8 cm) and not more than 3.5 inches (8.8 cm) from the anterior edge of the aitch bone. The foot shall be removed at or slightly above the hock joint. The tail, vertebrae, *rectus abdominis*, (flank muscle) cutaneous trunci, prefemoral lymph gland, and any other exposed lymph glands shall be removed. The skin and collar fat over the *semimembranosus* (cushion) shall be smooth and well rounded such that the innermost curvature of the skin is trimmed back at least half the distance from the stifle joint to the posterior edge of the aitch bone. The skin overlying the medial side (inside) of the *quadriceps femoris* shall be removed and fat overlying the *quadriceps femoris* and pelvic area shall be removed close to the lean. The fat thickness beneath the leg face measured at the skin edge and directly under the bone shall not exceed that indicated in the following schedule:

<u>Weight Range of Ham (pounds)</u>	<u>Maximum Fat Thickness</u>
A. 14 - 17 (6.4 - 7.7 kg)	1.25 in. (3.1 cm)
B. 17 - 20 (7.7 - 9.1 kg)	1.5 in. (3.8 cm)
C. 20 - 26 (9.1 - 11.8 kg)	1.75 in. (4.3 cm)
D. 26 (11.8 kg) and up	2.0 in. (5.0 cm)

**Item No. 401A - Pork Leg (Fresh Ham), Short Shank** - This item is as described in Item No. 401 except the shank shall be removed by a straight cut made at an approximate right angle to the shank bones exposing a cross section of the *gastrocnemius*.

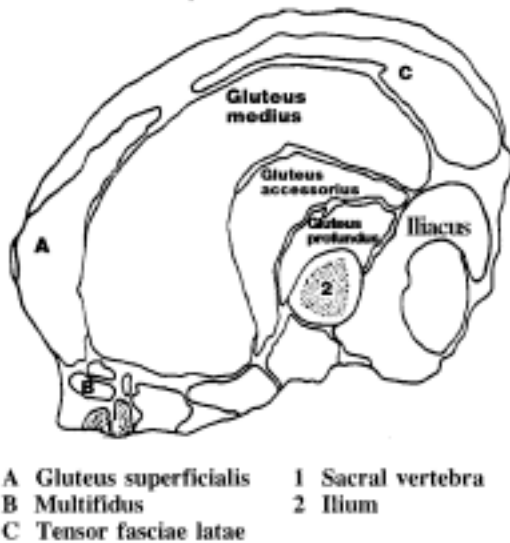
**Item No. 401B - Pork Leg (Fresh Ham), Sirloin On** - This item is as described in Item No. 401, except that the loin is removed by a straight cut immediately anterior to the hip bone and related cartilage leaving no less than 1-1/2 lumbar vertebrae on the leg. When specified, the shank shall be removed as described in Item No. 401A and may be labeled accordingly.

**Item No. 401C - Pork Leg (Fresh Ham), Semi-boneless** - This item is as described in Item No. 401A or 401B, except that the pelvic bone (aitch or hip), fat and lean above the aitch bone (oyster), vertebrae, flank and *ilio psoas* muscles are removed. The purchaser may specify one of the following options.

PSO:     1 - Sirloin off -   The leg shall be derived from Item No. 401A.  
          2 - Sirloin on -   The leg shall be derived from Item No. 401B.

When not specified, product shall comply with option 1. Unless otherwise specified, all skin shall be removed.

#### Loin-ham separation



#### Item No. 402 - Pork Leg (Fresh Ham),

**Skinned** - This item is as described in Item No. 401 except the skin and fat on the outside of the leg shall be trimmed. The skin shall be removed anterior to a straight line parallel to the leg face, which starts at a point that does not exceed 25 percent of the distance from the stifle joint to the leg face. The fat exposed by the removal of the skin shall be trimmed to not exceed 2 inch (13 mm) in depth at any point, which is 1.5 inches (3.8 cm), or more from the skin edge. However, fat thickness at the tail end of the pelvic area shall not exceed 1.0 inch (25 mm). When specified, all skin shall be removed.

**Item No. 402A - Pork Leg (Fresh Ham), Skinned, Short Shank** - This item is as described in Item No. 402 except the shank shall be removed as described in Item No. 401A.

**Item No. 402B - Pork Leg (Fresh Ham), Boneless** - This item is prepared from Item No. 401. All bones, cartilage, skin, *rectus abdominis*, (flank muscle) cutaneous trunci, fat and lean above the aitch bone, and exposed lymph glands shall be removed. The tendinous ends of shanks shall be removed so that the cross-sectional cut exposes not less than 75 percent lean. The loin end shall be exposed by a straight cut anterior to the *quadriceps femoris*. The cut shall not be less than 1.0 inch (25 mm) and not more than 3.0 inches (7.5 cm) from the anterior end of the femur pocket. Shank meat that is firmly attached may remain and shall be folded into the femur cavity.

**Item No. 402C - Pork Leg (Fresh Ham), Boneless, Short Shank, Trimmed** - This item is as described in Item No. 402B except the popliteal lymph gland shall be removed and surrounding (star) fat in excess of 1/4 inch (6 mm) shall be removed. Additionally, the shank shall be removed by a straight cut made at an approximate right angle to the length of the shank exposing the *gastrocnemius*.

**Item No. 402D - Pork Leg (Fresh Ham), Outside** - This boneless item shall consist of the outside muscles (*biceps femoris*, *gluteus superficialis*, and *semitendinosus*) from the leg. The *gastrocnemius* (inner shank) may remain; however, the "mouse" (*flexor digitorum superficialis*) shall be removed. The popliteal lymph gland and surrounding fat in excess of 1/4 inch (6 mm) in depth shall be removed. The purchaser may specify outsides from two legs to be reversed, and the boned surfaces placed together to produce a uniformly thick roast (when this option is specified, the purchaser may also specify the item to be divided into approximately equal portions by a straight cut(s) at a right angle to the length of the cut).

**Item No. 402E - Pork Leg (Fresh Ham), Outside, Trimmed** - This item is as described in Item No. 402D except that the *gastrocnemius* (inner shank) and the "mouse" (*flexor digitorum superficialis*) shall be removed from the *biceps femoris* and *semitendinosus* by a cut through the natural seam.

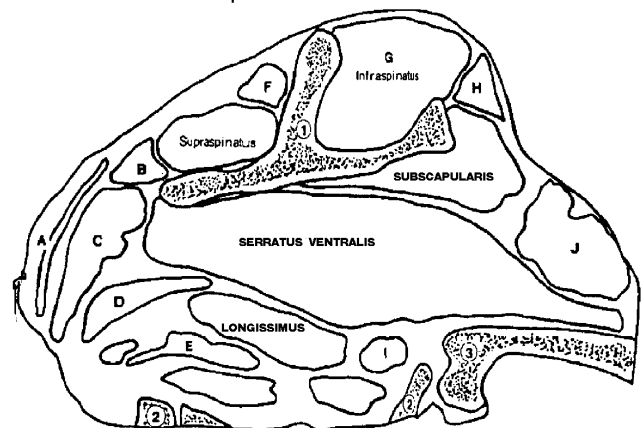
**Item No. 402F - Pork Leg (Fresh Ham), Inside** - This boneless item shall consist of the *semimembranosus* and related muscles of the inside portion of the leg which are removed from the outside and knuckle portions of the leg along the natural seam. All bones, cartilage, exposed heavy (opaque) connective tissue, lean and fat overlying the aitch bone (oyster), and the gracilis membrane (opaque portion) shall be removed. The purchaser may specify insides from two hams to be packaged together by placing the seamed surfaces together to produce a uniformly thick roast.

**Item No. 402G - Pork Leg (Fresh Ham), TBS, 3-Way, Boneless** - This item shall consist of inside (top), outside (bottom), and knuckle (sirloin tip) portions of the leg individually packaged and placed into the same container. The inside shall be as described in Item No. 402F. The outside shall be as described in Item No. 402E. The knuckle portion shall consist of the *tensor fasciae latae* and *quadriceps* group. All bones and cartilage shall be removed. The purchaser may specify this item to be derived from a leg with the sirloin on and require the boneless sirloin to be included (when included, shall be labeled 4-way). The purchaser may specify the packaging of individual roasts consisting of two insides, two outsides, two knuckles, and two sirloins (when applicable) be placed into the same container.

**Item No. 402H - Pork Leg (Fresh Ham), Tip**, - This item shall consist of the knuckle portion of the leg (the *tensor fasciae latae* and *quadriceps* group).

**Item No. 403 - Pork Shoulder** - The shoulder is separated from the side by a straight cut, approximately perpendicular to the length of the side, posterior to, but not more than 1.0 inch (25 mm) from, the tip of the elbow and shall not expose the elbow. The outer tip of the *subscapularis* muscle shall not extend past the dorsal edge of the base of the medial ridge of the blade bone. The foot shall be removed at or slightly above to the upper knee joint by a straight cut approximately perpendicular to the shank bones. The jowl shall be removed by a straight cut approximately parallel with the loin side that is anterior to,

Loin-shoulder separation



- |                        |                    |                     |
|------------------------|--------------------|---------------------|
| A Trapezius            | F, G Infraspinatus | 1 Scapula           |
| B Pectorales profundus | H Triceps Brachii  | 2 Thoracic vertebra |
| C Rhomboides           | I Iliocostalis     | 3 Rib               |
| D Splenius             | J Latissimus dorsi |                     |
| E Semispinalis capitis |                    |                     |

but not more than 1.0 inch (25 mm) from the innermost curvature of the ear dip. The neck bones, ribs, breastbones, associated cartilage, and breast flap (through the major crease) shall be removed. The fat and skin shall be beveled to meet the lean on the dorsal edge. The exterior fat thickness at the dorsal skin edge, measured at the center of the cut, shall not exceed that indicated in the following schedule:

<u>Weight Range of Shoulder (pounds)</u>	<u>Maximum Fat Thickness</u>
A. 8 - 12 (3.6 - 5.5 kg)	1.25 in. (3.1 cm)
B. 12 - 16 (5.5 - 7.3 kg)	1.5 in. (3.8 cm)
C. 16 - 20 (7.3 - 9.1 kg)	1.75 in. (4.3 cm)
D. 20 (9.1 kg) and up	2.0 in. (5.0 cm)

**Item No. 403A - Pork Shoulder, Long Cut** - This item is as described in Item No. 403, except that the shoulder shall be separated from the carcass by a straight cut approximately perpendicular to the length of the carcass between the 4th and 6th ribs.

**Item No. 403B - Outside Shoulder** - This item shall consist of the shank, humerus, and blade bone and associated outside muscles of the shoulder (Item Nos. 403 or 403A). It may be prepared from the carcass prior to separation of the loin and belly by cutting through the breast flap and *pectoralis superficialis* and following the natural seam to a point immediately medial to the blade cartilage. The shank shall be removed at or above the knee joint. The thick end (arm end) shall include the shank and humerus bones and overlying lean *latissimus dorsi*, *triceps brachii* group (cushion), and minor muscles associated with the humerus). The thin end (blade end) shall consist of the blade bone and muscles overlying the blade bone (*supraspinatus*, *infraspinatus*, *latissimus dorsi* and may contain the *subscapularis* and *teres major*). All sides shall be trimmed following the natural curvature of the major muscles and the scapula. The purchaser may specify all skin to be removed.

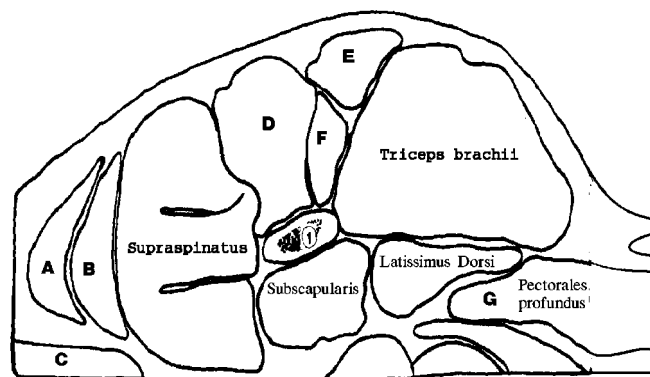
**Item No. 403C - Inside Shoulder, Boneless** - This item is prepared from the portion of the shoulder after removal of the outside shoulder as described in Item No. 403B. The loin shall be removed so that the *longissimus* is equal to or larger than the *spinalis dorsi*. All *trapezius* (false lean) shall be removed. The ventral edge shall be removed by straight cut perpendicular to the loin end that does not exceed 2.0 inches (5.0 cm) from *longissimus*, the anterior end is trimmed so that there is no evidence of the ear dip. All bones and cartilage shall be removed.

**Item No. 404 - Pork Shoulder, Skinned** - The shoulder is as described in Item No. 403 except the skin and fat on the outside of the shoulder shall be trimmed. The skin shall be removed dorsal to a straight line parallel to the dorsal side that starts at a point that does not exceed 25 percent of the distance from the elbow joint to the dorsal side. The fat exposed by the removal of the skin shall be trimmed to not exceed 1/2 inch (13 mm) in depth at any point 1.5 inches (3.8 cm) or more from the edge of the skin collar. At least traces of the false lean shall be exposed.

**Item No. 405 - Pork Shoulder, Picnic -**

This item is prepared from Item No. 403.

The butt shall be removed by a straight cut, dorsal to the shoulder joint, at an approximate right angle with the belly side. The jowl shall be removed by a straight cut approximately parallel with the belly side which is not more than 1.0 inch (25 mm) anterior from the *pectorales profundus*, (half moon muscle) measured on the butt side. The fat and skin shall be beveled to meet the lean on the dorsal edge. The fat thickness, measured at the center of the butt side, shall not exceed that indicated in the following schedule:



**A** Cutaneus faciei      **D** Infraspinatus      **1** Scapula  
**B, G** Pectorales profundus      **E** Deltoideus  
**C** Semispinalis capitis      **F** Teres minor

**Weight Range of Shoulder Picnic (pounds)**

- A. 4 - 6 (1.8 - 2.7 kg)
- B. 6 - 8 (2.7 - 3.6 kg)
- C. 8 - 12 (3.6 - 5.5 kg)
- D. 12 (5.5 kg and up)

**Maximum Fat Thickness**

- 5/8 in. (16 mm)
- 3/4 in. (19 mm)
- 1.0 in. (25 mm)
- 1.25 in. (3.1 cm)

**Item No. 405A - Pork Shoulder, Picnic, Boneless** - This item is prepared from Item No. 405. All bones, cartilage, and skin shall be removed. The belly side of the picnic shall expose a cross-section of the cushion (*triceps brachii* group). The butt side shall expose a full cross-section of the *supraspinatus* with no more than a slight enlargement of tendons. The jowl shall be removed by a cut that is not more than 1.0 inch (25 mm) anterior from the *pectorales profundus*, measured on the butt side. The tendinous ends of the shank, shall be removed to a point where a cross-sectional cut exposes at least 75 percent lean.

**Item No. 405B - Pork Shoulder, Picnic, Cushion** - This item shall consist of the *triceps brachii* muscles from Item No. 405A and shall be practically free of fat. Tendons shall be trimmed flush with the lean.

**Item No. 406 - Pork Shoulder, Boston Butt** - This item is as described in Item No. 403 except that the picnic is removed as described in Item No. 405. Skin, neck bones and related cartilage shall be removed. At least traces of false lean shall be exposed. When specified, the neck shall be removed by a straight cut approximately parallel to the loin side, immediately anterior to the *pectorales profundus*.

**Item No. 406A - Pork Shoulder, Boston Butt, Boneless** - This item is prepared from Item No. 406. All bones, cartilages, and skin shall be removed. The loin side of the butt shall expose the *longissimus* equal to or larger than the combined areas of the *splenius* and *semispinalis capitis*. The picnic side shall expose a cross-section of the *supraspinatus* with no more than a slight enlargement of tendons. The jowl shall be removed by a straight cut,

approximately parallel with the loin side, which is not more than 1.0 inch (25 mm) anterior to the *pectorales profundus*, measured on the picnic side. At least traces of false lean shall be exposed. The lean and fat overlying the blade shall remain firmly attached. When specified, the neck shall be removed by a straight cut approximately parallel to the loin side, immediately anterior to the *pectorales profundus*.

**Item No. 406B - Pork Shoulder, Boston Butt, Boneless, Special** - This item is as described in Item No. 406A except the *trapezius* shall be removed and the remaining roast shall be trimmed practically free of surface fat.

**Item No. 407 - Pork Shoulder Butt, Cellar Trimmed, Boneless** - The butt is as described in Item No. 406A except the lean and fat overlying the blade shall be removed.

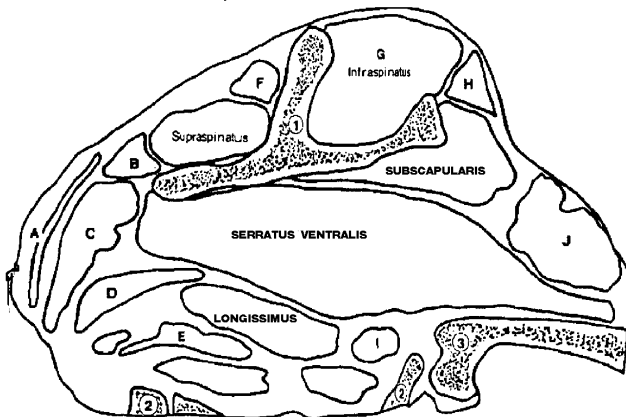
**Item No. 408 - Pork Belly** - The belly is prepared from the side after removal of the leg, shoulder, loin, fat back, and spareribs. All bones and cartilage shall be removed. Practically all leaf fat shall be removed. The fat back shall be removed by a straight cut not more than 1.5 inches (3.8 cm) from the outermost dorsal curvature of scribe line. The anterior (shoulder) and posterior (leg) ends of the belly shall be reasonably straight and parallel. No side of the belly shall be more than 2.0 inches (5.0 cm) longer than its opposing side. The width of the *rectus abdominis* (flank muscle) shall be at least 25 percent of the width of the belly on the leg end. The fat on the ventral side of the belly and adjacent to the flank shall be trimmed to within 3/4 inch (19 mm) from the lean. The area ventral to the scribe line shall be free of scores and "snowballs" (exposed areas of fat) which measure 3.0 square inches (19.4 sq. cm) or more. The belly shall be free of enlarged, soft, porous, dark, or seedy mammary tissue. The scribe line is not considered a score but shall be not more than 1/4 inch (6 mm) in depth at any point.

**Item No. 409 - Pork Belly, Skinless** - The skinless belly is as described in Item No. 408 except the skin is removed leaving a smooth skinned surface which is practically free of hair roots and scores.

**Item No. 409A - Pork Belly, Single Ribbed, Skinless** - This item is as described in Item No. 409 except that the rib bones are removed individually leaving the intercostal meat (rib fingers), costal cartilage, sternum, and *transversus abdominis* muscle intact. The purchaser may specify that skin may remain and that the costal cartilage and/or sternum be removed.

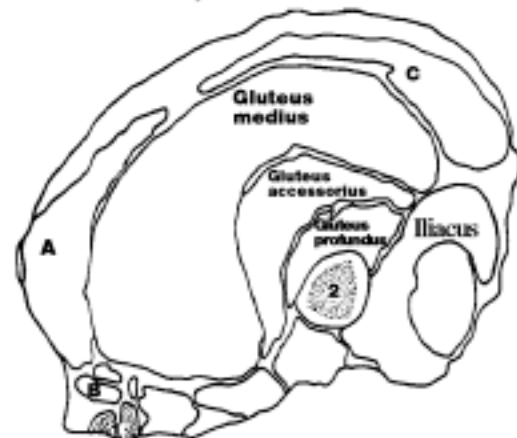
**Item No. 409B - Pork Belly, Center Cut, Skinless** - This item is as described in Item No. 409 except that the fat back shall be removed by a straight cut no more than 1/2 inch (13 mm) dorsal to the outermost curvature of the scribe line. The fat and teat line on the ventral edge shall be removed by a straight cut immediately ventral to lean edge.

Loin-shoulder separation



A Trapezius	F,G Infraspinatus	1 Scapula
B Pectorales profundus	H Triceps Brachii	2 Thoracic vertebra
C Rhomboides	I Iliocostalis	3 Rib
D Splenius	J Latissimus dorsi	
E Semispinalis capitis		

Loin-han separation



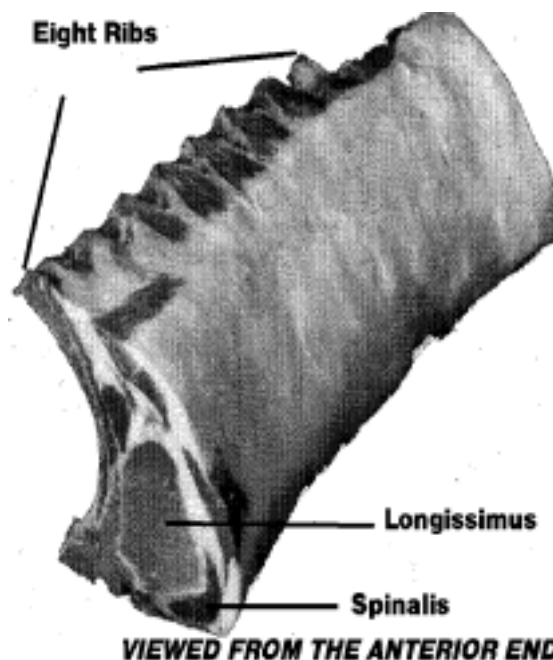
A Gluteus superficialis	1 Sacral vertebra
B Multifidus	2 Ilium
C Tensor fasciae latae	

**Item No. 410 - Pork Loin** - The loin is that portion of the side remaining after removal of the shoulder, leg, belly, and fat back leaving a portion of the blade

bone, its overlying lean and fat, not less than two (2) sacral, but no caudal vertebrae on the loin. The shoulder and leg shall be separated from the loin by straight cuts that are reasonably perpendicular to the split surface of the backbone. The outer tip of *subscapularis* muscle shall not extend past the center of the base of the medial ridge of the blade bone. The belly side shall be removed by a straight cut (a slight dorsal curvature is acceptable) which extends from a point which is ventral to but not more than 3.0 inches (7.5 cm) from the *longissimus* on the shoulder end, to a point on the leg end ventral to but not more than 1/2 inch (13 mm) from the tenderloin. Surface fat shall be trimmed to an average of 1/4 inch (6 mm) in depth or less except in the hip bone area. The hip bone area is defined as the area contained within two (2) parallel lines, 2.0 inches (5.0 cm) on either side of the anterior end of the hip bone and associated cartilage. Fat in the hipbone area shall be trimmed to the same contour as the rest of the trimmed fat surface of the loin. At least 2.0 inches (5.0 cm) of the false lean shall be exposed. Lumbar and pelvic fat shall be trimmed to 1/2 inch (13 mm) or less in depth. The tenderloin shall remain intact. The diaphragm and hanging tender shall be removed. The spinal cord groove shall be evident on at least 75 percent of the vertebrae.

**Item No. 410A - Pork Sirloin** - This item is derived from a loin as described in Item No. 410. The sirloin is the portion of the full loin that remains after the center-cut loin is removed by a straight cut anterior to the hipbone and related cartilage. Unless otherwise specified, a portion of the tenderloin may remain.

**Item No. 411 - Pork Loin, Bladeless** - The loin is as described in Item No. 410 except the blade bone, associated cartilage, and associated overlying lean and fat shall be removed. On the shoulder end, the *longissimus* shall be equal to or larger than the combined areas of the *splenius* and *semispinalis capitis*. When specified by the purchaser, all false lean (*trapezius* and *latissimus dorsi*) shall be removed in their entirety.



The purchaser may specify the following options for **all loins in the 412 and 413 series**. Option nos. 1-4 are belly removal options (ventral to the *longissimus*). If no belly removal option is specified, the distance shall be as specified within the item description. Option no. 5 is for trim.

PSO:	Option No.	Distance from the <i>longissimus</i> (Blade end x Sirloin end)
	1 -	2.0 in. (5.0 cm) x 1.0 in. (25 mm)
	2 -	1.0 in. (25 mm) x 1.0 in. (25 mm)
	3 -	0 in. x 0 in. (Immediately ventral)
	4 -	Other
	5 -	All false lean removed ( <i>trapezius</i> and <i>latissimus</i> )

**Item No. 412 - Pork Loin, Center Cut, 8 Ribs** - This item is prepared from Item No. 410. The blade and the sirloin portions are removed by straight cuts made approximately perpendicular to the split surface of the backbone and the length of the loin. The sirloin is removed anterior to the hipbone and associated cartilage exposing the *gluteus medius*. The blade portion shall be removed to leave not more than eight (8) ribs present. Floating rib(s) which do not show a cross-section at the belly side are exempt. The belly shall be removed by a straight cut (a slight dorsal curvature is acceptable) from a point that is ventral to, but not more than 4.0 inches (10.0 cm) from, the *longissimus* at the blade end to a point on the sirloin end which is ventral to, but not more than 3.0 inches (7.5 cm) from the *longissimus*. Surface fat shall be trimmed to an average of 1/4 inch (6 mm) in depth. Lumbar fat shall be trimmed to not exceed 1/2 inch (13 mm) in depth. The tenderloin shall



remain intact. The spinal cord groove shall be evident on at least 75 percent of the vertebrae.

**Item No. 412A - Pork Loin, Center Cut, 8 Ribs, Chine Bone Off** - This item is as described in Item No. 412. The tenderloin is removed. The protruding edge of the chine bone shall be removed such that the ventral edge of the spinal groove is not evident on the length of the loin. The *longissimus* shall not be scored.

**Item No. 412B - Pork Loin, Center Cut, 8 Ribs, Boneless** - This item is prepared from Item No. 412. The tenderloin, all bones and cartilage shall be removed. On the blade end, the *longissimus* shall be at least twice as large as the *spinalis dorsi*. The sirloin is removed anterior to the hipbone cartilage and shall expose the *gluteus medius*. The belly shall be removed by a cut ventral to, but not more than 4.0 inches (10.0 cm) from, the *longissimus* at the blade end to a point on the sirloin end ventral to, but not more than 3.0 inches (7.5 cm) from, the *longissimus*. To facilitate packaging, this item may be "butterflied" perpendicular to the length of the loin.

**Item No. 412C - Pork Loin, Center Cut, 11 Ribs** - This item is prepared from Item No. 410. The blade and the sirloin portions are removed by straight cuts made approximately perpendicular to the split surface of the backbone and the length of the loin. The sirloin is removed anterior to the hipbone and associated cartilage exposing the *gluteus medius*. The blade portion shall be removed to leave no more than 11 ribs present. Floating rib(s) which do not show a cross-section at the belly side are exempt. The belly shall be removed by a straight cut from a point that is ventral to, but not more than 3.0 inches (7.5 cm) from, the *longissimus* at the blade end to a point on the sirloin end ventral to, but not more than 3.0 inches (7.5 cm) from, the *longissimus* (a slight dorsal curvature is acceptable). The blade bone, related cartilage, and overlying lean and fat shall be removed. Lumbar fat shall be trimmed to not exceed 1/2 inch (13 mm) in depth. The tenderloin shall remain intact. The spinal groove shall be evident on at least 75 percent of the vertebrae.

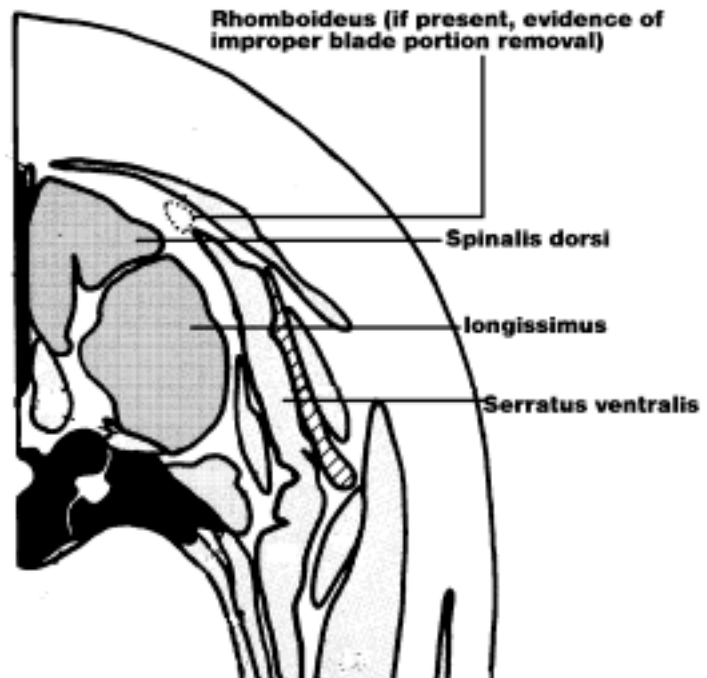
**Item No. 412D - Pork Loin, Center Cut, 11 Ribs, Chine Bone Off** - This item is as described Item No. 412C. The tenderloin is removed. The protruding edge of the chine bone shall be removed such that the ventral edge of the spinal groove is not evident on the length of the loin. The *longissimus* shall not be scored.

**Item No. 412E - Pork Loin, Center Cut, 11 Ribs, Boneless** - This item is prepared from Item No. 412C. The tenderloin, all bones and cartilage shall be removed. On the blade end, the *longissimus* shall be approximately equal to or larger than the *spinalis dorsi* and the *rhomboideus* shall not be present. The sirloin is removed anterior to the hipbone cartilage exposing the *gluteus medius*. The belly shall be removed by a cut from a point ventral to, but not more than 3.0 inches (7.5 cm) from, the *longissimus* at the blade end to a point on the sirloin end ventral to, but not more than 3.0 inches (7.5 cm) from the *longissimus*. To facilitate packaging, this item may be "butterflied" perpendicular to the length of the loin.

**Item No. 412F - Pork Loin, Center Cut, Rib End, Boneless**

- This item is as described in Item No. 412B or 412E, except that the sirloin end shall be removed posterior to the *spinalis dorsi*.

**Item No. 412G - Pork Loin, Center Cut, Rib End** - This item is as described in Item No. 412A or 412D, except the sirloin end shall be removed posterior to the last rib. To make the item roast ready, the purchaser may specify removal of the featherbones.



**Item No. 413 - Pork Loin, Boneless**

- This item is prepared from Item No. 410. All skin, bones, cartilage, the tenderloin, and lean and fat overlying the blade bone shall be removed. The leg end of the loin shall be exposed by a straight cut which shows no evidence of the *quadriceps femoris* nor the *longissimus*. The sirloin may be removed immediately anterior to the hipbone pocket. In such cases, both the *longissimus* and *gluteus medius* shall be exposed on the "leg" end.

On the shoulder end, the *longissimus* shall be equal to or larger than the combined areas of the *splenius* and *semispinalis capitis*. The belly shall be removed by a cut from a point ventral to but not more than 2.0 inches (5.0 cm) from the *longissimus* at the shoulder end to a point on the leg end, no more than 1.0 inch (25 mm), ventral to the *longissimus* and/or *gluteus medius* (a slight dorsal curvature is acceptable). Surface fat shall not exceed 1/4 inch (6 mm) in depth, except in the hip pocket that has no measurable fat requirement but shall be trimmed to the same contour as the rest of the trimmed fat surface. The hip bone area is defined as the area contained within two (2) parallel lines, 1.0 inch (25 mm) on either side of the hip pocket area. To facilitate packaging, this item may be "butterflied" perpendicular to the length of the loin.

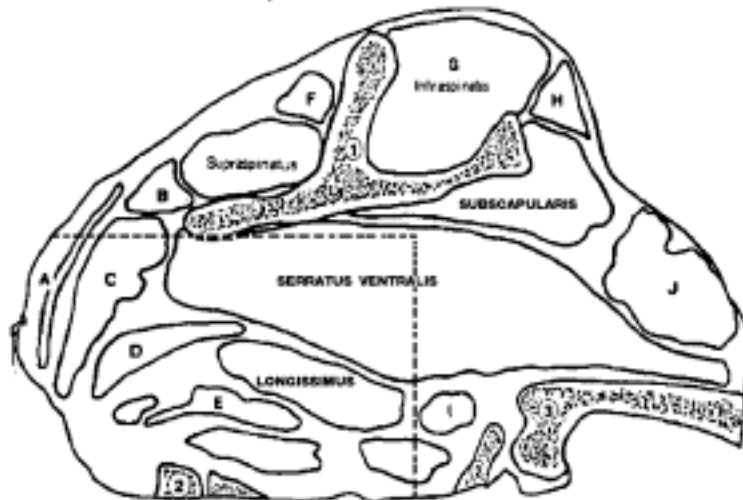
**Item No. 413A - Pork Loin, Roast, Boneless** - The loin is prepared as described in Item No. 413 except that the boneless loin shall be cut into two (2) pieces of approximately equal length. The pieces shall be positioned with the boned surfaces together, such that the blade and sirloin ends are not on the same end. The pieces shall be trimmed so that one piece of the boneless loin will not extend more than 1.0 inch (25 mm) in total length past its opposing piece. The boneless loin shall be netted or tied.

**Item No. 413B - Pork Loin, Boneless, Special** - This item is prepared as described in Item No. 413A except that the entire *infraspinatus*, *supraspinatus*, *latissimus dorsi*, and *trapezius*

muscles shall be removed. The belly shall be removed immediately ventral to the *longissimus* and *gluteus medius*. The *iliocostalis* and the *obliquus internus abdominis* muscles shall be removed. Powdered wheat gluten or other binding agents may be used. Binding agents and their application shall be in accordance with FSIS regulations. The purchaser may specify the use of other binding agents. When binding agents other than wheat gluten are used, the product name shall be changed accordingly. Binding agents shall be used to bind the boned surface of each half of the loin together.

**Item No. 414 - Pork Loin, Canadian Back** - This item is prepared from Item No. 410. All bones, cartilage, tenderloin, and lean and fat overlying the blade bone shall be removed. The shoulder and sirloin ends shall be removed by straight cuts approximately parallel to each other. On the shoulder end, the *longissimus* shall be equal to or larger than the combined areas of the *splenius* and *semispinalis capitis*, and the sirloin shall be removed immediately anterior to the hip cartilage. The belly side shall be removed immediately ventral to the *longissimus*.

Loin-shoulder separation

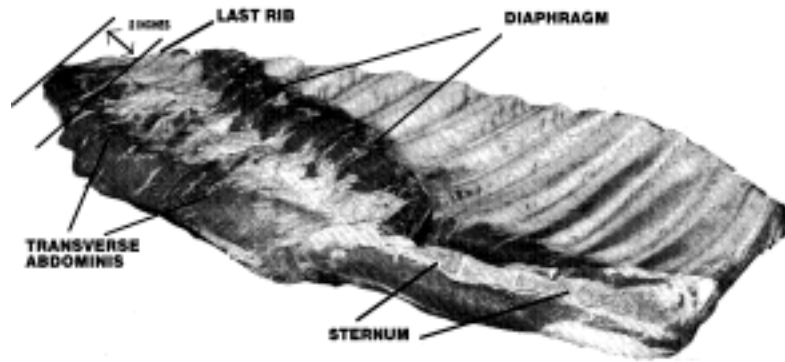


- |                        |                    |                     |
|------------------------|--------------------|---------------------|
| A Trapezius            | F, G Infraspinatus | J Scapula           |
| B Pectorales profundus | H Triceps Brachii  | 2 Thoracic vertebra |
| C Rhomboides           | I Iliocostalis     | 3 Rib               |
| D Splenius             | J Latissimus dorsi |                     |
| E Semispinalis capitis |                    |                     |

**Item No. 414A - Pork Sirloin, Boneless** - This item is prepared as described in Item No. 413. The sirloin is the portion of the full loin that remains after the center-cut loin is removed by a straight cut anterior to the hipbone and related cartilage.

**Item No. 415 - Pork Tenderloin** - This item is prepared from Item No. 410. The tenderloin shall be removed intact and shall consist of the *psoas major*, *psoas minor*, and *iliacus* only. The side strip muscle (*psoas minor*) shall be removed if not firmly attached. The anterior portion (tail end) shall be trimmed so that the tail is not split more than 1.0 inch (25 mm). The tenderloin shall be practically free of fat.

**Item No. 415A - Pork Tenderloin, Side Muscle Off** - The tenderloin shall be as described in Item No. 415 except the *psoas minor* (side strip muscle) shall be removed.



**Item No. 416 - Pork Spareribs** - Spareribs shall contain at least 11 ribs and associated costal cartilages and

may include portions of the sternum and diaphragm. The membranous portion of the diaphragm must be removed close to the lean. Any portion of the diaphragm not firmly attached shall be removed close to the inside surface of the ribs. The lean shall not extend more than 2.0 inches (5.0 cm) past the curvature of the last rib and costal cartilage. Heart fat on the inside surface of the ribs shall not exceed 1/4 inch (6 mm) average depth. Leaf fat over the diaphragm and *transverse abdominis* shall be trimmed practically free.

**Item No. 416A - Pork Spareribs, St. Louis Style** - The spareribs shall be as described in Item No. 416 except the sternum and the ventral portion of the costal cartilage shall be removed along with the flank portion. The breast shall be removed at a point that is dorsal to the curvature of the costal cartilage. When specified, the diaphragm shall be removed, and the spareribs shall be separated into two approximate equal portions by a lengthwise cut.

**Item No. 416B - Pork Spareribs, Brisket Bones** - This item consists of the sternum, costal cartilage and attached lean which have been removed from Item No. 416A.

**Item No. 416C - Pork Spareribs, Breast Off** - This item is as described in Item No. 416 except that the sternum is removed.

**Item No. 416D - Pork Breast Bones** - This item shall consist of the breast (sternum) bone and associated lean and fat.

**Item No. 417 - Pork Shoulder Hocks** - Shoulder hocks shall be separated from the front feet at or above the upper knee joint of the knee. Shoulder hocks shall be at least 2.0 inches (5.0 cm) in length.

**Item No. 417A - Pork Leg (Fresh Ham) Hocks** - Fresh ham hocks shall be separated from the hind feet at or above the hock joint. Fresh ham hocks shall be at least 2.0 inches (5.0 cm) in length.

**Item No. 418 - Pork Trimmings** - Trimmings shall be prepared from any portion of the carcass (Item No. 400) which yields product that will meet the end-item requirements. Trimmings shall be free of bones, cartilage, skin, seedy mammary tissue, exposed heavy

tendons and lymph glands (including the prefemoral, popliteal, prescapular, and other exposed lymph glands). The tendinous ends of shanks shall be removed to a point where a cross-sectional cut exposes at least 75 percent lean. Ground product is not permitted. Unless otherwise specified, trimmings derived from automatic deboning machines and/or advance lean retrieval systems shall be excluded.

**Item No. 419 - Pork Jowl** - The jowl is removed from the shoulder as described in Item No. 403. Jowls shall be reasonably rectangular in shape, trimmed practically free of surface glandular material, loose tissue, and bloody discoloration. Excessively trimmed or mutilated jowls are not acceptable. Unless otherwise specified, the jowls shall have all skin removed.

**Item No. 420 - Pig's Feet, Front** - The feet shall be removed at or above the upper knee joint of the front legs. The feet shall be trimmed practically free of hair and hair roots.

**Item No. 420A - Pig's Feet, Hind** - The feet shall be removed at or above the hock joint of the hind legs. The feet shall be trimmed practically free of hair and hair roots.

**Item No. 421 - Pork Neck Bones** - The neck bones shall contain at least two (2) cervical vertebrae and at least one (1), but not more than four (4) thoracic vertebrae, adjoining ribs and intercostal lean.

**Item No. 422 - Pork Loin, Back Ribs** - The back ribs shall consist of at least eight (8) ribs and related intercostal meat from a loin. The back rib sections shall be intact, and the bodies of the thoracic vertebrae shall be removed except that small portions of the vertebrae may remain between the rib ends. When specified, the "skin" (peritoneum) shall be removed from the inside surface of the ribs and intercostal meat.

**Item No. 423 - Pork Loin, Country-Style Ribs** - This item shall be prepared from the blade end of a pork loin and shall include not less than three (3) nor more than six (6) ribs. The chine bones shall be removed by a cut that exposes lean meat between the featherbones and ribs. Country-style ribs shall be divided into approximately equal portions by cutting through the flesh from the rib end (ventral) side to the feather bone side without severing the muscle cover (*trapezius*), leaving both portions attached. This cut leaves the blade bone and overlying lean and fat in one portion and the ribs and featherbones in the other.

As an alternative, the blade bone, related cartilage, and overlying lean and fat shall be removed. The chine bone shall be removed as described above. The country-style ribs shall be separated into approximately equal portions by cutting through the flesh where the chine bones were removed. This cut leaves the ribs in one portion and the featherbones in the other. Both portions shall be packed into the same container. The purchaser shall specify which method is preferred.

**IMPS Item No. 424 - Pork Loin, Riblet** - This item is derived from the transverse processes and associated lean from the lumbar vertebrae of any IMPS bone in pork loin after removal of the tenderloin and the loin eye. Riblets shall; contain no less than 4

transverse processes (sometimes referred to as “paddle” or “finger” bones); be held intact by associated lean; and include no more than two rib bones. This item shall be trimmed practically free of surface fat.

**Item No. 435 - Diced Pork** - Diced pork shall be prepared from any portion of the carcass that yields product that meets the end item requirements. Unless otherwise specified, inner shank (heel portion of the leg), shank meat and jowls shall be excluded. Dices shall be free of bones, cartilage, skin, heavy connective tissue, seedy mammary tissue, and lymph glands. When the purchaser allows inner shank, the *flexor digitorum superficialis* (“mouse” muscle) shall be removed from the *gastrocnemius* through the natural seams. To facilitate dicing, meat may be frozen and/or tempered, one time only. The meat shall be either hand-diced or mechanically diced (grinding is not permitted). Unless otherwise specified, at least 75 percent, by weight, of the resulting dices shall be of a size equivalent to not less than a 3/4 inch (19 mm) cube or not more than a 1.5 inches (3.8 cm) cube, and no individual surface shall be more than 2.5 inches (6.3 cm) in length. The surface and/or seam fat shall not exceed 1/4 inch (6 mm) thickness at any point. The purchaser may further specify fat limitation in terms of fat content percentage (refer to Section **I. D. FAT LIMITATIONS**).

**Item No. 435A - Pork for Stewing** - This item is as described in Item No. 435 except (unless otherwise specified) at least 85 percent, by weight, of the resulting dices shall be of a size equivalent to not less than a 3/4 inch (19 mm) cube or not more than a 1.5 inches (3.8 cm) cube and no individual surface shall be more than 2.5 inches (6.3 cm) in length. The fat thickness of the surface and/or seam fat shall not exceed 1/4 inch (6 mm) at any point. The purchaser may further specify fat limitation in terms of fat content percentage (refer to Section **I. D. FAT LIMITATIONS**).

**Item No. 435B - Pork for Kabobs** - This item is as described in Item No. 435 except (unless otherwise specified) at least 90 percent, by weight, of the resulting dices shall be of a size equivalent to not less than a 1.0 inch (25 mm) cube or not more than a 1.5 inches (3.8 cm) cube, and no individual surface shall be more than 3.0 inches (7.5 cm) in length. The fat thickness of the surface and/or seam fat shall not exceed 1/8 inch (3 mm) at any point.

#### **Item No. 496 - Ground Pork -**

**Material** - Unless otherwise specified, ground pork may be prepared from any portion of the carcass (Item No. 400). The meat shall be free of bones, cartilage, skin, seedy mammary tissue, heavy exposed tendons, exposed heavy (opaque) connective tissue, prefemoral, popliteal, prescapular lymph glands specifically and other exposed lymph glands shall be removed. The tendinous ends of shanks shall be removed so that a cross-sectional cut exposes at least 75 percent lean. Meat from automatic deboning machines is acceptable provided it is ground on the same day as deboning.

Ground pork may be derived from boneless meat that has been previously frozen and stockpiled. The purchaser may specify the maximum amount of previously frozen boneless meat that can be mixed with fresh chilled meat prior to final grinding.

When specified by the purchaser, "lean finely textured pork" may be combined with boneless pork meeting the above material requirements provided it does not exceed 20 percent by weight of the combined finished product. "Lean finely textured pork" shall be produced and labeled in accordance with FSIS regulations.

**Processing** - Grinding equipment shall have sharp knives and plates. Unless otherwise specified, the boneless meat shall be ground at least once through a plate having holes not larger than 1.0 inch (25 mm) in diameter. Alternatively, boneless pork may be chopped or machine cut by any method provided the texture and appearance of the product after final grinding is typical of ground pork prepared by grinding only. Unless otherwise specified, final grinding shall be through a plate having holes 3/16 inch (5 mm) in diameter. Pork may be thoroughly blended at least once prior to final grinding. However, the ground pork shall not be mixed after final grinding. Initial reduction in size, blending, final grinding and packaging shall be a continuous sequence.

The purchaser may specify the use of a bone collector/extruder system on the final grind (3/16 inch (5 mm) or smaller plate) to remove objectionable materials (bone, cartilage, connective tissue, etc.). Objectionable material removed during final grinding may not be reintroduced into the finished product. For certification purposes, the purchaser may waive examination for trimming defects provided (1) the use of a bone collector/extruder system is specified and (2) the producer assures that the other objectionable materials listed in the material requirements are removed.

When coarse ground pork is specified, boneless meat shall be ground once through a plate having holes no larger than 1.0 inch (25 mm) and no smaller than 5/8 inch (16 mm) in diameter. Alternatively, the boneless meat may be ground twice, with the smallest plate having holes no larger than 1.0 inch (25 mm) and no smaller than 3/4 inch (19 mm) in diameter. Coarse ground meat may be blended after grinding or between grinds to assure uniformity of fat content. The term "coarse ground" shall appear on the product label.

**Item No. 496A - Ground Pork and Vegetable Protein Product** - This item is approved for use in Child Nutrition Programs and is as described in Item No. 496 except that vegetable protein product (VPP) shall be added. Source (i.e., soy), Type (flour, concentrate, or isolate), and Texture (granular or textured) of VPP shall be specified by the purchaser. The VPP may be used dry, partially hydrated, or fully hydrated. If not specified, the dry VPP shall be fully hydrated to yield a minimum of 18 percent protein. To determine the maximum amount of water to be mixed with the dry VPP to yield 18 percent protein in the mixture, the following equation shall be used:

$$\frac{[\text{Percent protein on "as is" basis}]}{18} - 1 = x$$

x = maximum pounds of water to be added to each pound of dry VPP.

The VPP shall be hydrated for the length of time listed on the product label. If this information is not available, the product shall be hydrated until all water is absorbed. The purchaser shall specify any level of substitution of hydrated VPP in the combined finished

product up to 30 percent. If not specified, the maximum percent of hydrated protein product in the combined finished product shall not exceed 20 percent. The hydrated VPP shall be used in the same working day in which it was hydrated. The hydrated VPP shall be blended with the raw meat (in the specified ratio) following the initial reduction in size.

The VPP must meet the nutritional specifications established by the USDA, Food and Nutrition Service Regulations. To ensure compliance, the VPP used must have information on the label stating, "This product meets USDA-FCS requirements for use in meeting a portion of the meat/meat alternate requirement of the child nutrition programs." Labeling of the finished product must reflect the terms "Vegetable Protein Product" or "Textured Vegetable Protein Product" as appropriate in the ingredient statement (i.e., textured vegetable protein product (Soy Flour, Zinc Oxide, Niacinamide, Ferrous Sulfate, Copper Gluconate, Vitamin A Palmitate, Calcium Pantothenate, Thiamine Mononitrate (B<sub>1</sub>), Pyridoxine Hydrochloride (B<sub>6</sub>), Riboflavin (B<sub>2</sub>), Cyanocobalamin (B<sub>12</sub>)).

**Item No. 496B - Pork Patty Mix** - This item is as described in Item No. 496A except that VPP does not need to comply with FNS Regulations.

**Item No. 496C - Pork Patty Mix, Not to exceed (NTE) 10% Fat** - This item is as described in Item No. 496, except that the fat content shall not exceed 10 percent. Additional ingredients may be added to enhance product acceptability. Such ingredients shall not exceed 10 percent of the combined finished product. The purchaser may specify the ingredients that will be allowed.

## Portion-Cut Products

(To be evaluated for end-item requirements as in the IMPS QUALITY ASSURANCE PROVISIONS.)

**Item No. 1400 - Pork Steak Cubed** - Cubed steaks shall be prepared from any portion of the carcass that yields product that meets the end-item requirements. However, shank and inner shank meat shall be excluded. Unless otherwise specified, the steaks shall be cubed (while in the fresh chilled state) twice at approximate right angles. Knitting of 2 or more pieces and folding the meat when cubing is permissible. After cubing, surface and seam fat shall not exceed 15 percent of the total area on either side of the steak. Individual steaks shall remain intact when suspended 1/2 inch (13 mm) from the outer edge. The steaks shall be free of heavy connective tissue, bones, cartilage, and lymph glands.

**Item No. 1401 - Pork Steaks Cubed, Special** - This item is as described in Item No. 1400 except the steaks shall be prepared from any combination of lean from the leg, sirloin, loin,



and shoulder sections (excluding shank and inner shank meat) of the carcass. Knitting of 2 or more pieces and folding the meat when cubing is not permissible.

**Item No. 1402 - Pork Cutlets** - Cutlets shall be prepared from any combination of lean from the leg, loin, sirloin, or shoulder sections (excluding shank and inner shank meat) of the carcass which yields product that meets the end-item requirements. The cutlets shall be free of heavy (opaque) connective tissue, bones, cartilage, and lymph glands. When specified, the raw materials shall be mechanically tenderized by using the multiple probe method (pinning) not more than one time. Pressing, knitting, or folding two pieces of meat together is not permissible. Surface and seam fat shall not exceed an average of 1/8 inch (3 mm) in thickness and the thickness at any one point shall not exceed 1/4 inch (6 mm). Surface fat, measuring 0.1 inch (2 mm) or more in thickness, shall not exceed 50 percent of the circumference of the cutlet. Individual cutlets shall remain intact when suspended 1/2 inch (13 mm) from the outer edge. Alternatively, the purchaser may specify surface and seam fat limitations in terms of maximum surface area percentage. Both surface and seam fat of the total cut surface on either side of the cutlet shall not exceed the percentage specified by the purchaser.

**Item No. 1402G - Pork Leg Cutlets** - This item is as described in Item No. 1402 except that boneless pork shall be derived from any item meeting the end item requirements for Item No. 402G.

**Item No. 1406 - Pork Boston Butt Steaks** - The steaks are prepared from Item No. 406. The slicing of steaks shall start on the loin side of the butt.

**Item No. 1407 - Pork Shoulder Butt Steaks, Boneless** - The steaks are prepared from Item No. 407. The slicing of steaks shall start on the loin side of the butt.

For all loin portion cut items, the purchaser may specify the following options:

PSO - **Tail length** - If not specified, the tail length will not exceed 1.0 inch (25 mm) from the *longissimus*.

Option	
No.	<u>Distance from <i>longissimus</i></u>
1 -	3.0 in. (7.5 cm)
2 -	2.0 in. (5.0 cm)
3 -	1.0 in. (25 mm)
4 -	No tail (trimmed to meet specified fat trim)
5 -	Other

**Pockets** - When specified by the purchaser loin portion items in the **1412 and 1413 series**, the pocket shall be made by a cut into the *longissimus* leaving no less than 1/4 inch (6 mm) and not more than 1/2 inch (13 mm) of intact lean from the edge to the innermost point of the pocket. The cut shall not puncture either surface containing the cross-section of the *longissimus*.

**Item No. 1410 - Pork Loin Chops** - The chops are prepared from Item No. 410.

**Item No. 1410A - Pork Loin, Rib Chops** - This item is prepared from the rib portion of Item Nos. 412A or 412C. Each chop shall consist of at least one rib.

**Item No. 1410B - Pork Loin, End Chops** - Pork end chops may be derived from the blade and sirloin portions of any IMPS pork loin.

**Item No. 1411 - Pork Loin Chops, Bladeless** - The chops are prepared from Item No. 411.

**Item No. 1412 - Pork Loin Chops, Center Cut** - The chops are prepared from Item Nos. 412 or 412C.

**Item No. 1412A - Pork Loin Chops, Center Cut, Chine Bone Off** - The chops are prepared from Item Nos. 412A or 412D.

**Item No. 1412B - Pork Loin Chops, Center Cut, Boneless** - The chops are prepared by from Item Nos. 412B or 412E.

**Item No. 1412E - Pork Loin Chops, Center Cut, One Muscle, Boneless** - This item may be prepared from Item Nos. 412B or 412E except that the sirloin shall be removed approximately 1.5 (3.8 cm) inches anterior to the hip cartilage so that the *longissimus* appears as one muscle. All muscles other than the *longissimus* and the *multifidus dorsi* shall be excluded. This item shall be practically free of fat and sliced at the thickness and/or portion weight specified by the purchaser. This item is referred to as the "America's Cut" when sliced to a thickness of not less than 1.25 inches (3.2 cm) or not more than 1.5 inches (3.8 cm).

**Item No. 1413 - Pork Loin Chops, Boneless** - The chops are prepared by cutting Item No. 413.

**Item No. 1413B - Pork Loin, End Chops, Boneless** - The boneless pork chops may be derived from the blade and sirloin portions of any IMPS boneless loin.

**Item No. 1438 - Pork Steaks, Flaked and Formed, Frozen** - The steaks shall be prepared from boneless pork that complies with the material requirements of Item No. 496 and shall be flaked (grinding is not permitted) and formed. The flaking and forming process shall be in compliance with FSIS Regulations. Product shall comply with fat content requirements of Item No. 496. The purchaser shall specify shape and weight of steaks. When specified, the flaked and formed steaks may be cubed (the term cubed" may be included in the product label). When specified the steaks shall be breaded and labeled appropriately. The breading and its application shall be in accordance with FSIS Regulations.

**Item No. 1438A - Pork Sandwich Steaks, Flaked, Chopped, Formed and Wafer Sliced, Frozen** - The steaks shall be prepared from boneless pork that complies with the material requirements of Item No. 496. The flaking, chopping, forming, and slicing process shall be in compliance with FSIS Regulations and shall produce steaks that are moderately fine textured. Product shall comply with fat content requirements of Item No. 496. Each steak shall consist of two or more thin slices weighing approximately 1.0 ounce (28 g) each. No more than a minor amount of green/brown/gray rings shall be present. Steaks shall be packaged with paper separators between each steak. Unless otherwise specified, slices shall be approximately 4.75 x 7.5 inches (11.9 x 18.8 cm). The purchaser shall specify weight and/or number of slices per pound.

**Item No. 1438B - Pork Steaks, Sliced and Formed, Frozen** - The steak shall be prepared from boneless pork that complies with Item No. 418. The slicing and forming process shall be in accordance with FSIS Regulations. Ingredients may be added for the purpose of tenderizing and binding and shall appear on product label. The purchaser shall specify weight, shape, and/or thickness of steaks.

**Item No. 1495 - Coarse Chopped Pork** - This item shall be prepared from any portion of the carcass which yields product meeting the end-item requirements. However, shank meat and jowls shall be excluded. All skin, bones, cartilage, heavy connective tissue, and prefemoral, popliteal, prescapular lymph glands and any other exposed lymph glands and all surface and seam fat in excess of 1/8 inch (3 mm) shall be removed. The boneless meat shall be ground once through a plate with holes measuring 3/4 inch (19 mm). Alternatively, the boneless meat may be chopped or machine-cut by any method that yields equivalent results. However, if specified by the purchaser, the meat shall be hand-diced to the size desired.

The purchaser may specify the following options for **Item Nos. 1496, 1496A, 1496B, and 1496C**.

- Perforations (to facilitate heat transfer during cooking)
- Shape (oval, round, square, etc.)
- Style (plate fill method)

**Item No. 1496 - Ground Pork Patties**- This item shall be prepared from Item No. 496.

**Item No. 1496A - Ground Pork and Vegetable Protein Product Patties** - The patties shall be prepared from Item No. 496A.

**Item No. 1496B - Pork Patties** - This item is prepared from Item No. 496B.

**Item No. 1496C - Pork Patties, NTE 10% Fat**- The patties shall be prepared from Item No. 496C.

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# PORK SKELETAL CHART

Location, Structure and Names of Bones

